

(c) *Special preparation*—(1) For design qualification and periodic testing, packagings must be tested with closures in place. For production testing, packagings need not have their closures in place. Removable heads need not be installed during production testing.

(2) For testing with closures in place, vented closures must either be replaced by similar non-vented closures or the vent must be sealed.

(d) *Test method*. The packaging must be restrained under water while an internal air pressure is applied; the method of restraint must not affect the results of the test. The test must be conducted, for other than production testing, for a minimum time of five minutes. Other methods, at least equally effective, may be used in accordance with appendix B of this part.

(e) *Pressure applied*. An internal air pressure (gauge) must be applied to the packaging as indicated for the following packing groups:

(1) Packing Group I: Not less than 30 kPa (4 psi).

(2) Packing Group II: Not less than 20 kPa (3 psi).

(3) Packing Group III: Not less than 20 kPa (3 psi).

(f) *Criteria for passing the test*. A packaging passes the test if there is no leakage of air from the packaging.

[Amdt. 178-97, 55 FR 52723, Dec. 21, 1990, as amended at 56 FR 66286, Dec. 20, 1991; Amdt. 178-106, 59 FR 67522, Dec. 29, 1994; 66 FR 45386, Aug. 28, 2001]

§ 178.605 Hydrostatic pressure test.

(a) *General*. The hydrostatic pressure test must be conducted for the qualification of all metal, plastic, and composite packaging design types intended to contain liquids and be performed periodically as specified in § 178.601(e). This test is not required for inner packagings of combination packagings. For internal pressure requirements for inner packagings of combination packagings intended for transportation by aircraft, see § 173.27(c) of this subchapter.

(b) *Number of test samples*. Three test samples are required for each different packaging. For packagings constructed of stainless steel, monel, or nickel, only one sample is required for periodic

retesting of packagings. Exceptions for the number of aluminum and steel sample packagings used in conducting the hydrostatic pressure test are subject to the approval of the Associate Administrator.

(c) *Special preparation of receptacles for testings*. Vented closures must either be replaced by similar non-vented closures or the vent must be sealed.

(d) *Test method and pressure to be applied*. Metal packagings and composite packagings other than plastic (e.g., glass, porcelain or stoneware), including their closures, must be subjected to the test pressure for 5 minutes. Plastic packagings and composite packagings (plastic material), including their closures, must be subjected to the test pressure for 30 minutes. This pressure is the one to be marked as required in § 178.503(a)(5). The receptacles must be supported in a manner that does not invalidate the test. The test pressure must be applied continuously and evenly, and it must be kept constant throughout the test period. In addition, packagings intended to contain hazardous materials of Packing Group I must be tested to a minimum test pressure of 250 kPa (36 psig). The hydraulic pressure (gauge) applied, taken at the top of the receptacle, and determined by any one of the following methods must be:

(1) Not less than the total gauge pressure measured in the packaging (i.e., the vapor pressure of the filling material and the partial pressure of the air or other inert gas minus 100 kPa (15 psi)) at 55 °C (131 °F), multiplied by a safety factor of 1.5. This total gauge pressure must be determined on the basis of a maximum degree of filling in accordance with § 173.24a(d) of this subchapter and a filling temperature of 15 °C (59 °F);

(2) Not less than 1.75 times the vapor pressure at 50 °C (122 °F) of the material to be transported minus 100 kPa (15 psi), but with a minimum test pressure of 100 kPa (15 psig); or

(3) Not less than 1.5 times the vapor pressure at 55 °C (131 °F) of the material to be transported minus 100 kPa (15 psi), but with a minimum test pressure of 100 kPa (15 psig).

Packagings intended to contain hazardous materials of Packing Group I

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must be tested to a minimum test pressure of 250 kPa (36 psig).

(e) *Criteria for passing the test.* A package passes the hydrostatic test if, for each test sample, there is no leakage of liquid from the package.

[Amdt. 178–97, 55 FR 52723, Dec. 21, 1990, as amended at 56 FR 66286, Dec. 20, 1991; Amdt. 178–99, 58 FR 51534, Oct. 1, 1993; Amdt. 178–102, 59 FR 28494, June 2, 1994; 65 FR 50462, Aug. 18, 2000; 66 FR 45386, 45390, Aug. 28, 2001; 73 FR 57007, Oct. 1, 2008; 78 FR 60755, Oct. 2, 2013]

§ 178.606 Stacking test.

(a) *General.* All packaging design types other than bags must be subjected to a stacking test.

(b) *Number of test samples.* Three test samples are required for each different packaging. For periodic retesting of packagings constructed of stainless steel, monel, or nickel, only one test sample is required. Exceptions for the number of aluminum and steel sample packagings used in conducting the stacking test are subject to the approval of the Associate Administrator. Notwithstanding the provisions of § 178.602(a) of this subpart, combination packagings may be subjected to the stacking test without their inner packagings, except where this would invalidate the results of the test.

(c) *Test method—(1) Design qualification testing.* The test sample must be subjected to a force applied to the top surface of the test sample equivalent to the total weight of identical packages which might be stacked on it during transport; where the contents of the test sample are non-hazardous liquids with specific gravities different from that of the liquid to be transported, the force must be calculated based on the specific gravity that will be marked on the packaging. The minimum height of the stack, including the test sample, must be 3.0 m (10 feet). The duration of the test must be 24 hours, except that plastic drums, jerricans, and composite packagings 6HH intended for liquids shall be subjected to the stacking test for a period of 28 days at a temperature of not less than 40 °C (104 °F). Alternative test methods which yield equivalent results may be used if approved by the Associate Administrator. In guided load tests, stacking stability must be assessed after completion of

the test by placing two filled packagings of the same type on the test sample. The stacked packages must maintain their position for one hour. Plastic packagings must be cooled to ambient temperature before this stacking stability assessment.

(2) *Periodic retesting.* The test sample must be tested in accordance with:

(i) Section 178.606(c)(1) of this subpart; or

(ii) The packaging may be tested using a dynamic compression testing machine. The test must be conducted at room temperature on an empty, unsealed packaging. The test sample must be centered on the bottom platen of the testing machine. The top platen must be lowered until it comes in contact with the test sample. Compression must be applied end to end. The speed of the compression tester must be one-half inch plus or minus one-fourth inch per minute. An initial preload of 50 pounds must be applied to ensure a definite contact between the test sample and the platens. The distance between the platens at this time must be recorded as zero deformation. The force *A* to then be applied must be calculated using the formula:

Liquids: $A = (n-1) [w + (s \times v \times 8.3 \times .98)] \times 1.5$;

Solids: $A = (n-1) (m \times 2.2 \times 1.5)$

Where:

A = applied load in pounds

m = the certified maximum gross mass for the container in kilograms.

n = minimum number of containers that, when stacked, reach a height of 3 meters.

s = specific gravity of lading.

w = maximum weight of one empty container in pounds.

v = actual capacity of container (rated capacity + outage) in gallons.

And:

8.3 corresponds to the weight in pounds of 1.0 gallon of water.

.98 corresponds to the minimum filling percentage of the maximum capacity for liquids.

1.5 is a compensation factor that converts the static load of the stacking test into a load suitable for dynamic compression testing.

2.2 is the conversion factor for kilograms to pounds.

(d) *Criteria for passing the test.* No test sample may leak. In composite packagings or combination packagings,